


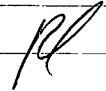




Work Order ID 64555


Wednesday, December 08, 2010 10:24:10 A


Page 1


Item ID:	D3315-2	Accept		Setup	Start	
Revision ID:						
Item Name:	Wearplate				Stop	
Start Date:	12/8/2010	Start Qty:	5.00			
Required Date:	12/22/2010	Req'd Qty:	5.00			
Reference:						

Approvals:	Process Plan:		Date:	10/12/8	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3315	Rev B								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D if necessary		<input checked="" type="checkbox"/> Dwg Rev: B	<input type="checkbox"/> Prog Rev: B	<input type="checkbox"/> 2-Deburr				
1010.060									

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

B10-12-22

7

Pro →

B10-12-23

8/10/12/23

76

W/O: 64555		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/12/23	#120	took Qty 1 For QC inspection template	S	10/12/23	1		S 10/12/23

Part No: D3315-2 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Wednesday, December 08, 2010 10:24:10 A

Page 2

Accept

Revision ID:

Item Name: Wearplate

Start Date: 12/8/2010 **Start Qty:** 5.00

Required Date: 12/22/2010 **Req'd Qty:** 5.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

130

0.00

Small Fab

0.00

Memo

Deburr if necessary

140

0.00

NC BRAKE

0.00

Memo

1- Form using DT8751 Die as per Dwg D3315Rev: B ☐ 2- Form using
DT8179 Die and form joggle using DT8157 as per Dwg D3315 ☐ Rev: B

150

0.00

QC6- Inspect dimensions to drawing

0.00

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
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Wednesday, December 08, 2010 10:24:10 A

Page 3

Accept

Revision ID:

Item Name: Wearplate

Start Date: 12/8/2010 **Start Qty:** 5.00

Required Date: 12/22/2010 **Req'd Qty:** 5.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

**Insp.
Stamp**

160

0.00

Large Fab

Large Fab

0.00

Large Fab

Memo

Weld hard surface using D3315-2T3 as per QSI 004 and Dwg D3315 Rev:

	Qty	Part Number	Description	Batch	A/R
---	-----	-------------	-------------	-------	-----

N/A

7560 Hardcoat Rod

Batch
M115552

170

0.00

QC

QC10- Inspect visual per QSI004- ground welds

0.00

Quality Control

Memo

180

0.00

QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Wednesday, December 08, 2010 10:24:10 A

Page 4

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Revision ID:						
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Required Date:	12/22/2010	Req'd Qty: 5.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3,5.6) per OSI005 4.3 <i>M112588</i> Memo START TIME: <i>2:05</i> BOVEN TEMPERATURE: <i>330°</i> FINISH TIME: <i>2:35</i>	0.00 0.00				<i>6</i>	<i>PR 11-2-13</i>		
200  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>6</i>	<i>8</i>	<i>11/01/14</i>	
210  Packaging Packaging	Packaging Memo Identify on inside surface using a permanent fine point marker with the following: <input type="checkbox"/> TCCA-PDA, Dart Aerospace Ltd. <input type="checkbox"/> P/N: D3315-2, B/N: BXXXXXX <input type="checkbox"/> For Product Eligibility see PDA04-17 <input type="checkbox"/> and Stock <input type="checkbox"/> Location: <i>496</i>	0.00 0.00				<i>11/14</i>	<i>(64)</i>	<i>SP</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 64555

Wednesday, December 08, 2010 10:24:10 A

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Required Date:	12/22/2010	Req'd Qty:	5.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21- Final Inspection - Work Order Release	0.00							
 QC	Memo	0.00							
Quality Control									

U 4.01.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, December 08, 2010 10:24:14 AM

Page 1
T

Work Order ID: 64555



Parent Item: D3315-2



Parent Item Name: V. earplate

Start Date: 12/8/2010

Required Date: 12/22/2010

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: A 05.05.12 New issue KJ/JLM
IPP Rev:B As per Rev B 06-03-24 JLM
IPP RevC now water jet 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M1010S16GA

Purchased

No

100

sf

84.5250

1.695

8.475



B 10-12-22

1010/1025 sheet 16GA

Location

Loc Qty

Loc Code

MAT19

84.525

111410

84.525

111410

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	64555
Description: Wearplate		Part Number:	D3315-2
Inspection Dwg: D3315	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.266 x 0.450	+0.006/-0.001 x +/-0.010	0.267 x 0.452	X		URB02	
4.402	+/-0.010	4.400	2		U	
4.137	+/-0.010	4.137	2		U	
3.550	+/-0.010	3.557	2		U	
5.464	+/-0.010	5.466	2		U	
5.214	+/-0.010	5.215	2		U	
1.224	+/-0.010	1.224	2		U	
2.57	+/-0.030	2.566	2		U	
6.273	+/-0.010	6.266	2		U	
8.224	+/-0.010	8.224	2		T B01	
9.515	+/-0.010	9.515	2		T	
11.429	+/-0.010	11.429	2		T	
15.474	+/-0.010	15.474	2		T	
16.379	+/-0.010	16.379	2		T	
21.360	+/-0.010	21.360	2		T	
23.474	+/-0.010	23.474	2		T	
26.273	+/-0.010	26.273	2		T	
29.42	+/-0.030	29.42	2		T	
0.060	+/-0.010	0.057	2		U	
Ø0.300	+0.006/-0.001	0.300	2		U	

Measured by: KB	Audited by: S	Prototype Approval:	N/A
Date: 10-12-22	Date: 10/12/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.28	New Issue	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

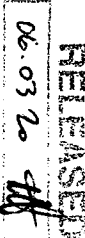
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

NO. 64335



- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED

*TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN	84	UNKNOWN BY	84	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	
DATE	06.01.31			DRAWING NO. D3315 SHEET 1 OF 4 TITLE WEARPLATE SCALE 1:12
A	04.09.10	NEW ISSUE		
B	06.01.31	UPDATE DIMENSIONS		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

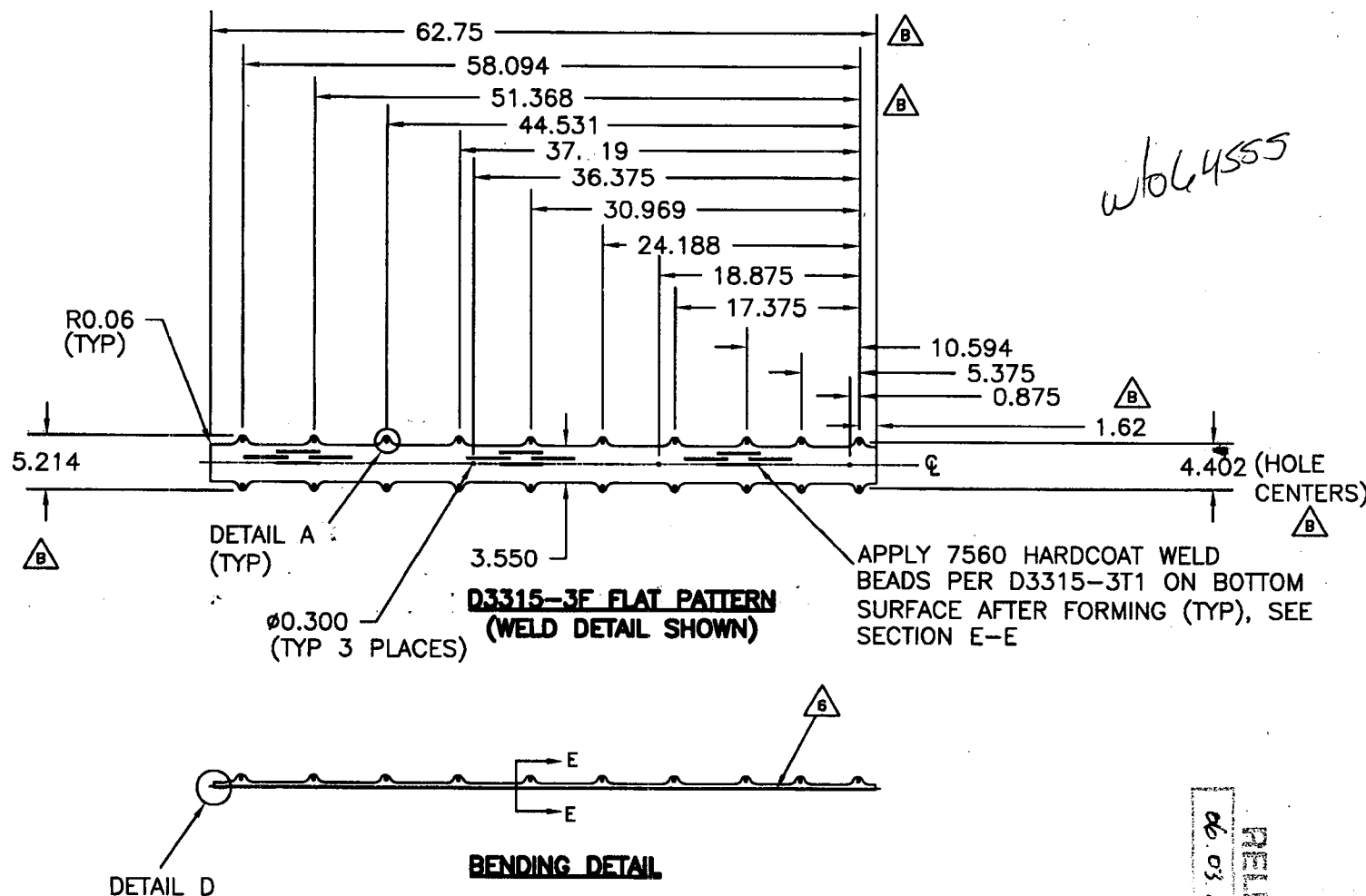
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	84	DRAWN BY	84	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	D3315
DATE	06.01.31	TITLE	WEARPLATE	SHEET 2 OF 4	REV. B
SCALE	1:16				



D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

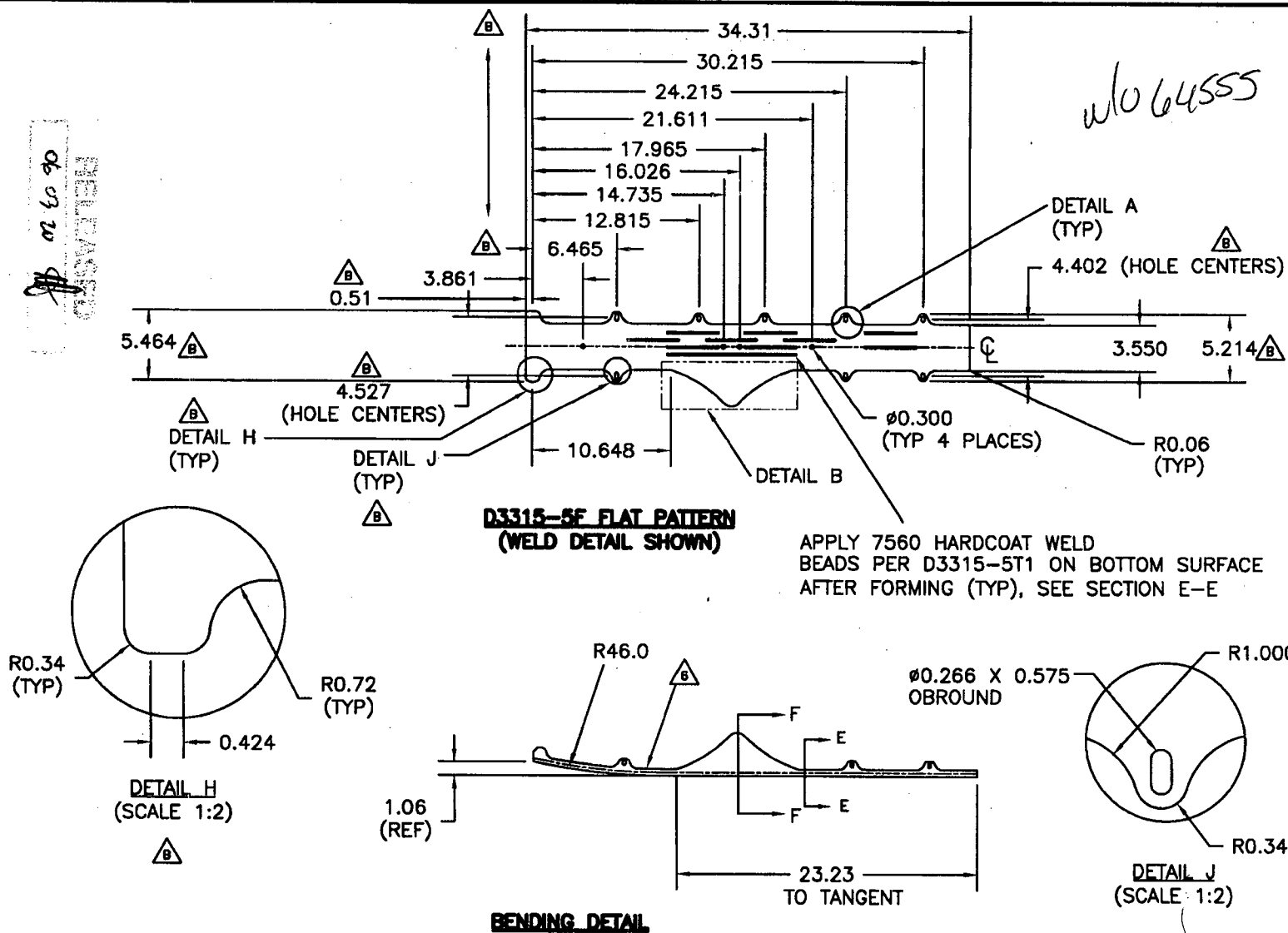
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DH	DRAWN BY	DH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B SHEET 3 OF 4
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>		
DATE	06.01.31	TITLE			
		WEARPLATE			



D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

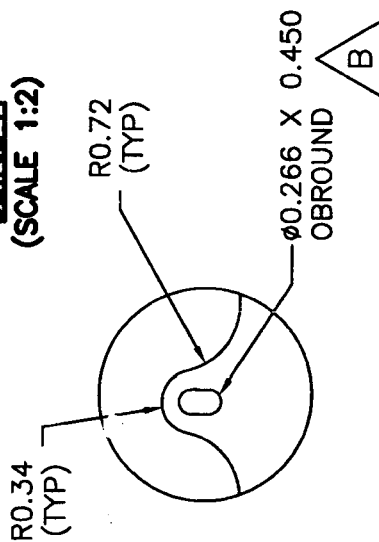
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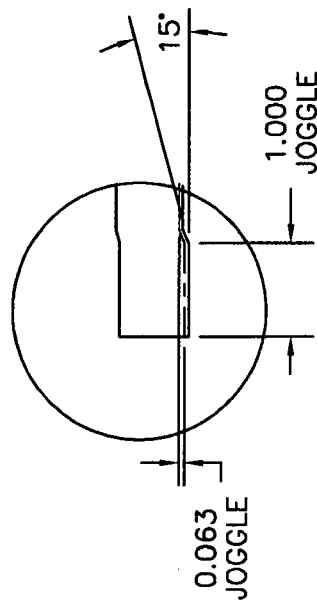
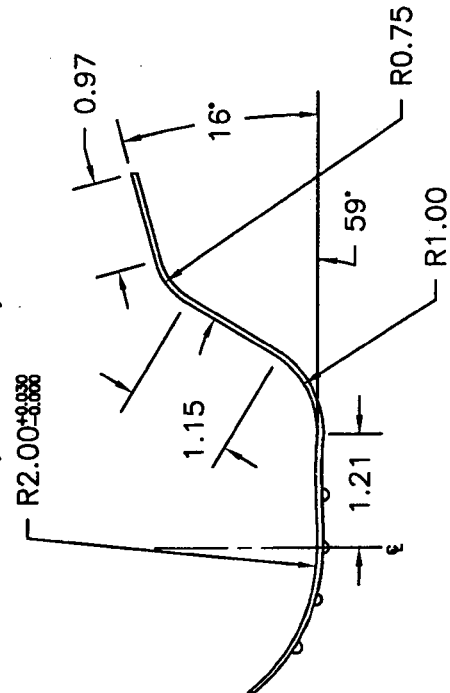
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DART

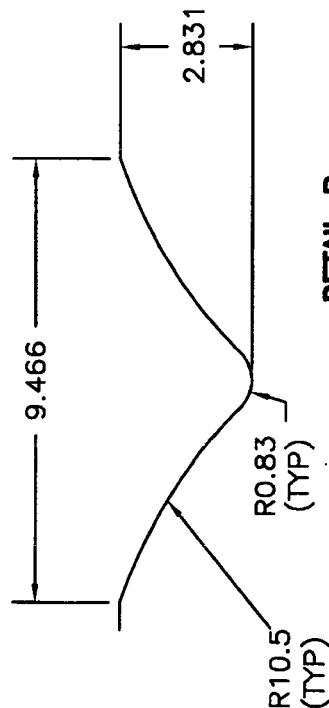
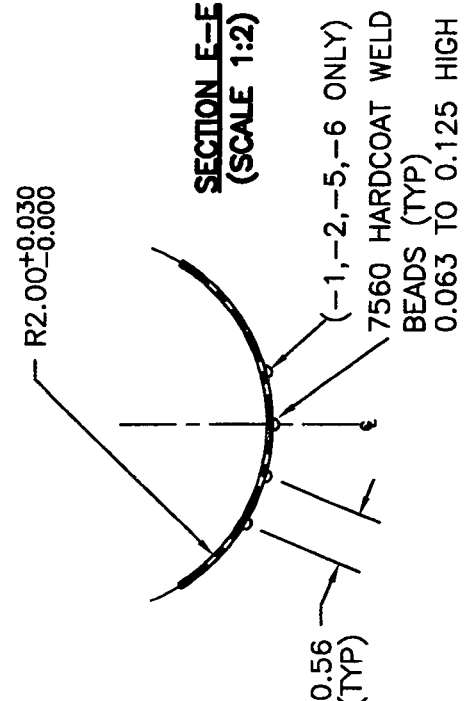
DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3315	REV. B SHEET 4 OF 4
DATE 06.01.31	TITLE WEARPLATE		SCALE NTS

DETAIL A
(SCALE 1:2)

RELEASED
06.03.20

**DETAIL D**
(SCALE 1:2)**SECTION F-F**
(SCALE 1:2)

B

DETAIL B
(SCALE 1:4)**SECTION E-E**
(SCALE 1:2)

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